

Date: Tuesday, 12/20/2005 3:39:12 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SKIDTUBE
Job Number	: 25333		
Estimate Number	: 11545		
P.O. Number	: <i>N/A</i>	Part Number	: D204635011
This Issue	: 12/20/2005	Drawing Number	: <i>N/A</i>
S.O. No.	: <i>N/A</i>	Project Number	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Revision	: <i>N/A</i>
First Issue	: <i>N/A</i>	Material	: <i>N/A</i>
Type	: LANDING GEAR	Due Date	: 1/30/2006
Previous Run	: 25326	Qty:	1
		Um:	Each
Written By	: <i>SEE COMMENT BELOW</i>		
Checked & Approved By	: <i>SEE COMMENT BELOW</i>		
Comment	: Est Rev:G 02.08.28 Removed QC5 KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile and Type labels as per PPP D204-635-011 CHG004

DA 06-02-14

2.0	25333A	SKIDTUBE
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**Comment:** Sub-Component Pick:

Qty	Part Number	Description	Batch
1	D204-635-041	Skidtube Assembly	<i>B25333</i>

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

4.0	K10003	D205-634-011 Saddle Kit
-----	--------	-------------------------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	K10003	Saddle Kit	<i>B24429</i>

C 206/02/15 (1)

5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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**Comment:** INSPECT 100% KITS FOR COMPLETENESS*C 206/02/15 (1)*

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 06/02/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 3:39:12 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 25333

Part Number: D204635011

Job Number:



Rev 3 06/2/15 (1)

Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D204-635-011

Location: _____

PPP Rev: _____

Rev 3 06/2/15

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Sgt 06/02/16

(1)

SP 06/02/16

Job Completion



W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 3:39:35 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SKIDTUBE
Job Number : 25333A	
Estimate Number : 11546	
P.O. Number :	Part Number : D204635041
This Issue : 12/20/2005 S.O. No. :	Drawing Number : D2590 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : 11 Type : LANDING GEAR	Drawing Revision : C
Previous Run :	Material :
Written By :	Due Date : 1/30/2006 Qty: 1 Um: Each
Checked & Approved By :	
Comment : Est Rev:F 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D25001190	Ext'n -1" Beam Tube 4"
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Comment: Qty.: 1.0400 Each(s)/Unit Total : 1.0400 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2500-1-190	Skid Tube Extrusion	B21778 Pm 05-12-29 ①

2.0	D2597	204 Web
-----	-------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2597	204 Web	B25336 Pm 05-12-30 ①

3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage Pm 05-12-29 ①

2-Cut D2500-1-190 per Dwg D2590 if necessary Deburr ends Pm 05-12-29 ①

3-Drill pilot holes using drill jig DT 8149 & DT8711-1&-2 Pm 05-12-29 ①

4-Acid etch and Alodine tube per QSI 005 4.1 A.M. 05-12-30 ①

5-Open holes to 0.500" as per Dwg D2590 without cutting fluid Pm 05-12-30 ①

6-Countersink holes as per Dwg D2590 without cutting fluid Pm 05-12-30 ①

7-Deburr and blow out all chips from inside of tube Pm 05-12-30 ①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 3:39:35 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 25333A

Part Number: D204635041

Job Number:



Seq. #:

Machine Or Operation:

Description :

8-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 ~~m1879~~ m19134

Sikaflex expire date: 06-06-20

Start Time: 10:15

Fin Time: 9:00

Pm^c 05-12-30 ①

4.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend as per program D2590.C on CNC Bender

Pm^c 06-01-05 ①

5.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut tubes as per Dwg. D2590 .

Pm^c 06-01-05 ①

2-Deburr ends after cutting. Remove alodine from around holes

Pm^c 06-01-05 ①

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 06-01-09 ①

7.0

D25763

Step (Machining Detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2576-3 Step

B22141

BE 06-01-09 ①

8.0

D2579

Crossbolt Spacer



Comment: Qty.: 17.0000 Each(s)/Unit Total : 17.0000 Each(s)

Pick:

Qty Part Number Description Batch

17 D2579 Spacers

B24313

BE 06-01-09 ①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 3:39:35 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 25333A

Part Number: D204635041

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Prepare tube for welding D2576-3 StepRemove alodine as required.

BE 06-01-09 ①

2-Weld step D2576 as per Dwg. D2590 and QSI 004

A/R

Aluminum Rod

M19100

BE 06-01-09 ①

3-Weld crossbolt spacers D2579 as per Dwg. D2590 and QSI 004. For D2579

spacers, weld one

side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R

Aluminum Rod

M19100

BE 06-01-09 ①

4-Grind welds as per Dwg D2590 Grind flush ridge made from bending

am 06-01-10 ①

5-Drill holes for wearplates using DT 8218 Open holes to 19/64", adjust stopper not to hit crosstubes. Deburr

am 06-01-10 ①

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2590. Deburr holes

am 06-01-10 ①

7-Drill pilot holes for aft cap using DT 8215 Open holes to #6 Drill bit. Deburr

am 06-01-10 ①

8-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

am 06-01-11 ①

10.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

Inspect weld and Counterbore work to Step 20

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

am 06-02-13

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 02 14

13.0

D25771

Wearplate Fwd



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 3:39:36 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 25333A

Part Number: D204635041

Job Number:



Seq. #: Machine Or Operation: Description :

1 D2577-1 Wearplate

B24371

FC

14.0 D25773 Wearplate Aft



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2577-3	Wearplate	B24372

FC

15.0 D25777 Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2577-7	Wearplate	B21607

FC

16.0 ALS71032130 Insert



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
38	ALS7-1032-130	Inserts	B18293

FC

17.0 AN960JD10L Washer



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
38	AN960JD10L	Washer	M19185

FC

Permit Change

18.0 AN34A Bolt



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
38	AN3-4A	Bolt	M1602

FC 0602141

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 3:39:36 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 25333A

Part Number: D204635041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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19.0	D25941	Plug
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Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
10	D2594-1	Plug	24379

FC

20.0	D25943	O-Ring
------	--------	--------



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
10	D2594-3	O-Ring	094104

FC

21.0	D2855	Cap
------	-------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

123425

FC

22.0	AN35A	Bolt
------	-------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

114526

FC

23.0	AN960JD10L	Washer
------	------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

119185

FC

24.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2590. Use a drop of Sikaflex on insert holes before installing wearplates

A/R

Sikaflex-291

114597

Sikaflex expire date: 06 18 26

FC

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

FC

3-Inspect for foreign object per QSI 024

FC 06 02 14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
6-2-14	20	Should say O ring Permanent Change					<i>[Signature]</i>	<i>[Signature]</i>

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 3:39:36 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 25333A

Part Number: D204635041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Install 2855 Aft Cap as per Dwg D2590 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R

Sikaflex-291

m19597

Sikaflex expire date: *06 1806*

FC 06 02 14

5-Wing Walk as per Dwg D2590 and QSI 005 4.4

Batch:

m18850

25.0

QC5

INSPECT WORK TO CURRENT STEP



ml 06 02 15



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

26.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/02/16

Job Completion



W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2590	REV. C SHEET 1 OF 2
DATE 98.08.28		TITLE 204 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.28	REDRAWN, INCLUDED DEO 9094/9097	

RELEASED
98/09/11 DS

QTY	Part Number	Description
X	D2590-041	SKIDTUBE ASSEMBLY
*	D2500-1	EXTRUSION
1	D2597	204 WEB
1	D2575	AFT CAP
1	D2576-3	STEP
17	D2579	CROSS BOLT SPACER
10	D2594-1	PLUG
10	D2594-3	O-RING
1	D2577-1	WEARSHOE
1	D2577-3	WEARSHOE
1	D2577-7	WEARSHOE
38	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
40	AN3-4A	BOLT
40	AN960JD10L	WASHER

08-28
P 08-28

DEOS	
EFFECTIVE	98/12/14

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 169.5 INCHES *
- 3) INSERT D2597 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-204 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (38 PLACES) AFTER FINISH. INSTALL AN3-4A BOLTS AND AN960JD10L WASHERS WITH SIKAFLEX-241.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2597 WEB.
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (10 PLACES).

REVIEWING
LED COPY
ENDMENT
CHECK

25333A

Diagram illustrating the grinding locations on a propeller cross-section:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- DEEP STEP
- LOCATION RIDGE ON UNDERSIDE OF D2576
- $\frac{1}{4}$

Technical drawing of a bolted joint assembly. The drawing shows a cross-section of a bolt passing through a plate. The bolt is labeled "AN3-4A BOLT (1)" and "AN960JD10L WASHER (1) (2 PLACES)". The plate is labeled "D2575 CAP". The bolt is secured with a nut and washer. The drawing includes a dimension line indicating a distance of "0.40". A note at the top right states "SEAL WITH SIKAFLEX-241". A note at the top left states "DRILL PRIOR TO D2575 CAP INSTALLATION (2 PLACES)". A note at the top center states "#0.208".

D2579 SPACER

WEB (REF)

AFTER PERFOR

1. CHA
2. INS
3. WEI

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[illegible]

Figure 1 is a plan view diagram of a road layout. It shows a straight section of length 1.4 units, followed by a curve. The distance between the hole and the tangent point is 1.0 unit. The distance between the hole and the tangent point is 13.4 units. The distance between the hole and the tangent point is 37.5 units. The distance between the hole and the tangent point is 6.5 units. The distance between the hole and the tangent point is 25.4 units. The distance between the hole and the tangent point is 11.5 units. A dashed line indicates the curve's path, and a solid line indicates the straight section. A triangle with the number 4 is shown at the end of the curve.

D2577-4T ASSEMBLY DETAIL

WELD AS PER DETAIL B

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

0.5

1.5

1.5

D

P

P

P

P

1.5

1.5

REFER TO DETAIL C

D2577-3

D2577-7

D2577-1

AN3-4A BOLT (1)


AN960J10L WASHER (1)

(38 PLACES)

8

REF 48

RELEASED
98/09/17 BS

DESIGN <i>RAH</i>	DRAWN BY <i>CF</i>	 DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>RAH</i>	APPROVED	DRAWING NO. D2590	REV. C SHEET 2 OF 2
DATE 98.08.28		TITLE 204 SKIDTUBE ASSEMBLY	SCALE 1:24



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. DEO 9124	REV. A SHEET 1 OF 1
DATE 98.12.12		TITLE CHANGE TO AFT CAP	SCALE NTS
A	98.12.12	NEW ISSUE	

DART ENGINEERING ORDER

AMENDS DRAWING D2580 REV. C
AMENDS DRAWING D2590 REV. C

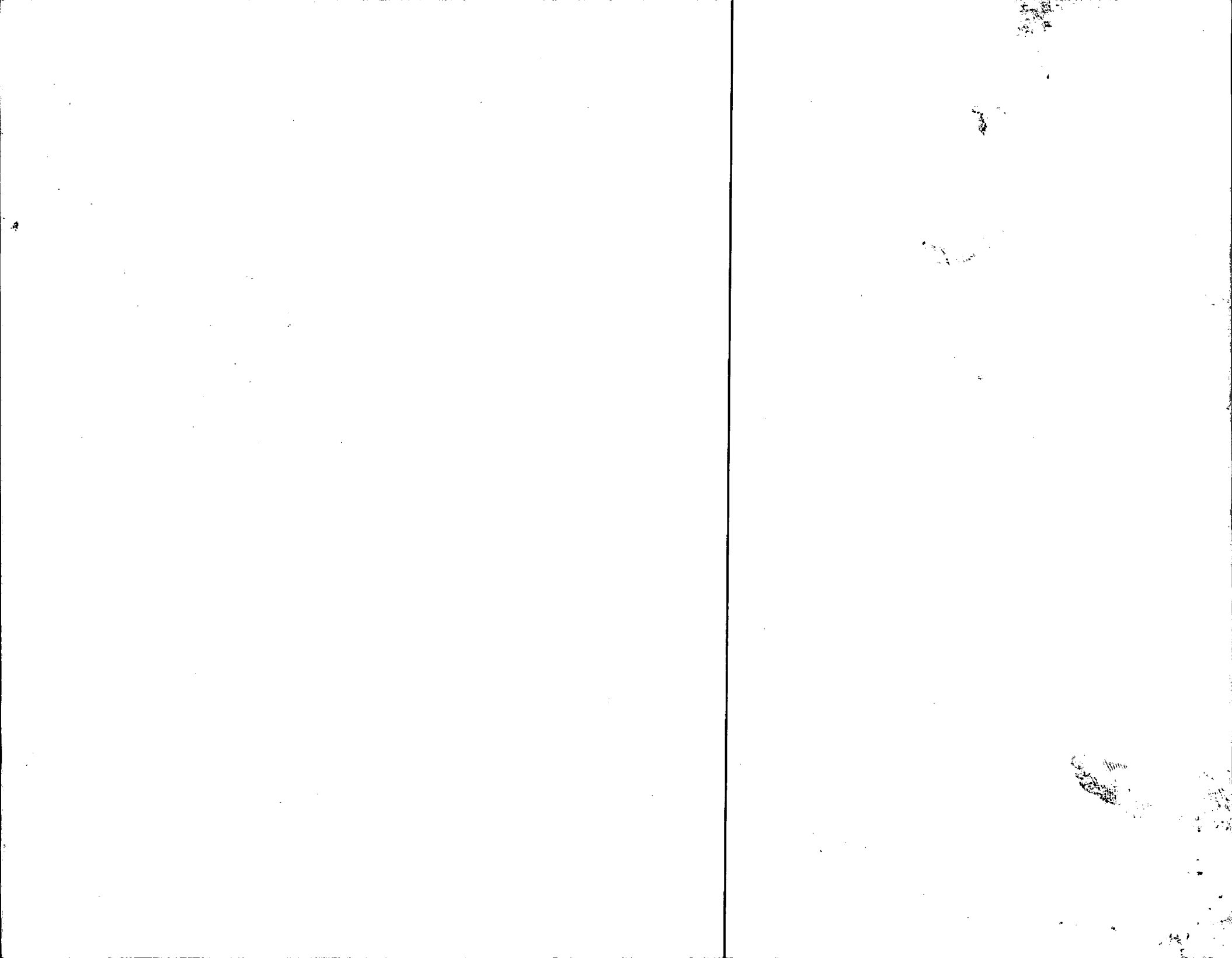
REPLACE: (1) D2575 CAP (SPUN)
(2) AN3-4A BOLT

WITH: (1) D2855 CAP (CASTING)
(2) AN3-5A BOLT

RELEASED
98.12.14 DS

100%
SUBJECT TO - EXCHANGE
WITH BOLT
WORK ORDER

NC 25333A



Date: Tuesday, 7/25/2006 11:43:01 AM
 User: Jean-Luc Menard

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: CUSTOM
Job Number	: 28028		
Estimate Number	: 10804		
P.O. Number	: N/A	Part Number	: Z_CUSTOM
This Issue	: 7/25/2006 S.O. No. : N/A	Drawing Number	: Z_CUSTOM
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 7/25/2006 Type : N/A	Drawing Revision	: N/A
Previous Run	: 27979	Material	: N/A
Written By	: _____	Due Date	: 8/1/2006
Checked & Approved By	: _____	Qty:	1 Um: Each
Comment	: Update D205-634 Skidtube With dsi 9344 & DSI9180 K10003		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D35331	Set Screw
-----	--------	-----------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Set Screw

Batch: B28029

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Update all kits D205-634-011 With Dsi9344 & dsi9180 Paperwork

Batch: B25952 B26870
 Batch: B26328 B26875 B26869
 Batch: B26310 B26332
 Batch: B25592 B25686
 Batch: B26335
 Batch: B26867 x 1 } 634
 Batch: B26329 x 1 } -011
 Batch: B26331 x 1
 Batch: B26330 x 1
 Batch: B26333 x 1
 Batch: B26334 x 1 } 634
 Batch: B25818 } -041 → 25817
 Batch: B25819
 Batch: 25690 } 635
 Batch: 25691
 Batch: 25334
 Batch: 25333

Update all kits K10003 With Dsi9344 & dsi9180 Paperwork

Batch: B26352 x 3
 Batch: B26848 x 2
 Batch: _____